

Work Order ID 58857 - |

May 19, 2010 10:28:49 AM

TODAY 11
ORD



Page 1

Item ID: D3953-17

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Spacer

Start Date: 5/19/10 Start Qty: 18.00



Cust Item ID:

Required Date: 5/26/10 Req'd Qty: 18.00



Customer:

Reference:

Approvals: Process Plan:

U

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3953	C

100



Waterjet

FLOW CNC Waterjet

304 .375X 3"

Memo

0.00

BB 10-5-19

1-Cut as per Dwg D3953

Dwg Rev: C

Prog Rev: C

2-Drill holes as per dwg

3-Deburr if necessary

BB 10/05/19

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

BB 10-5-19

(21)
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58857

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Page 2

Item ID: D3953-17

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Spacer

Stop



Start Date: 5/19/10 Start Qty: 18.00



Cust Item ID:

Required Date: 5/26/10 Req'd Qty: 18.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
Code

Qty

Accept
QtyReject
QtyReject
Number

Stamp

S 10/05/19

⊕

130



Small Fab

Small Fab

Memo

1- OPEN HOLES AS PER DWG

0.00

0.00

2- DEBURR IF NECESSARY

S 10/05/19

⊕

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S 10/05/19

⊕

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Work Order ID 58857

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Item ID: D3953-17

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Spacer

Stop



Start Date: 5/19/10 Start Qty: 18.00



Cust Item ID:

Required Date: 5/26/10 Req'd Qty: 18.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

150



Packaging

Packaging

Identify as per dwg & Stock Location: GA

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

MF 10-5-19

10/05/2019

MF 10-5-19

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Picklist Print

May 19, 2010 10:28:47 AM

Page 1

Work Order ID: 58857



Parent Item: D3953-17



Parent Item Name: Gas Spring Spacer

Start Date: 5/19/10

Required Date: 5/26/10

Comments: IPP RevA: New issue DD verified by:EC
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Start Qty: 18.00

Required Qty: 18.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304B0.375X03.000						100	f	3.4000	0.03125	7		

M304 SS bar .375 x 3.00



Location Loc Qty Loc Code

MAT53	3.4	
113679	3.4	

113679

(21)

1810-5-19

W/O:		WORK ORDER CHANGES					
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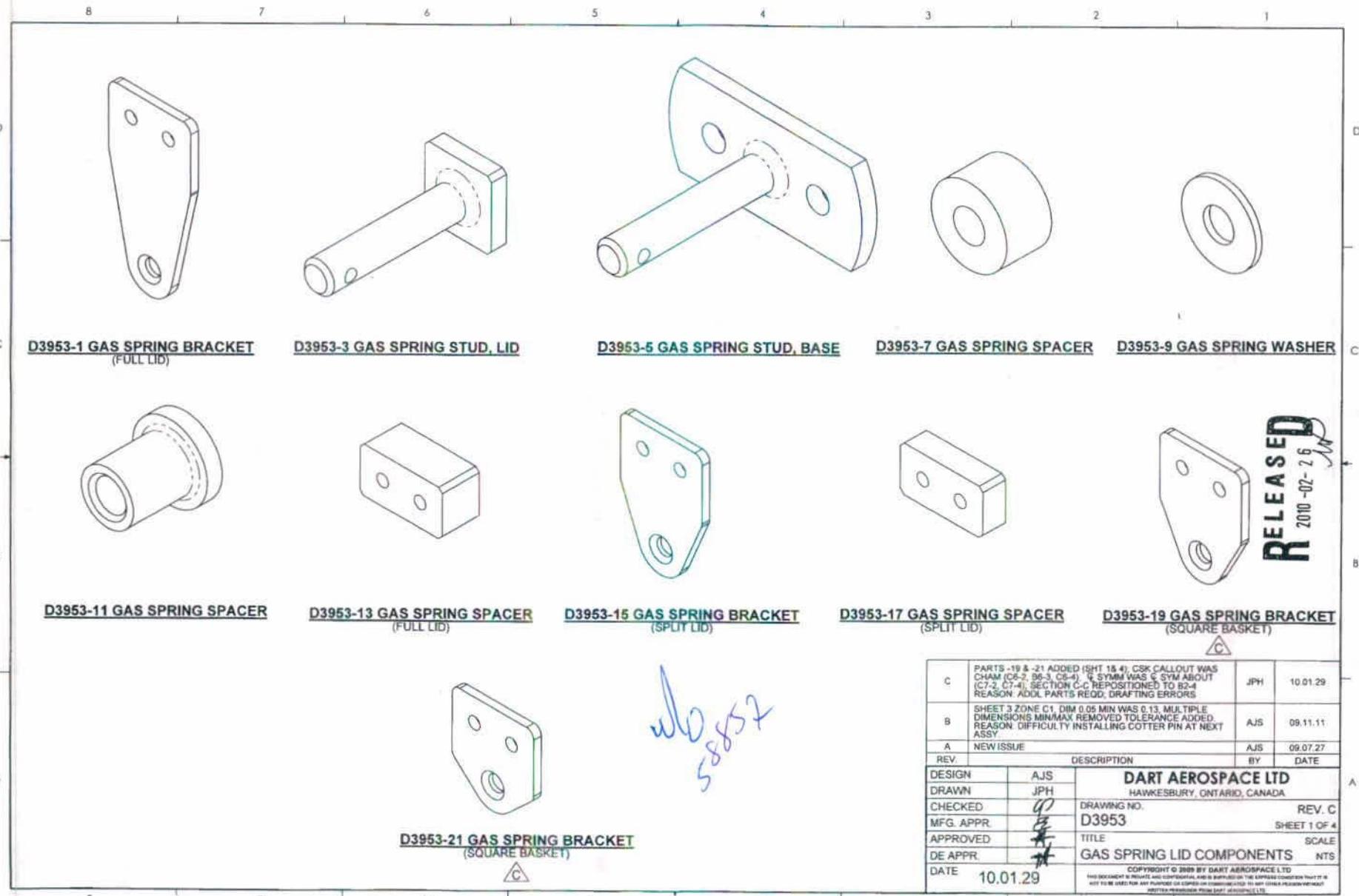
DART AEROSPACE LTD	Work Order:	5005X
Description: Gas Spring Spacer	Part Number:	D3953-17
Inspection Dwg: D3953 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-5-19	Date:	W/05/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ	MM



C	PARTS -19 & -21 ADDED (HT 18.4) CSK CALLOUT WAS CHANGED TO 18.4. 8.2MM WAS SYM OUT (HT 2. C-C 4). SECTION C-C REPOSITIONED TO B3-4. REASON: ADDL PARTS REQD. DRAFTING ERRORS			JPH	10.01.29
B	SHEET 3 ZONE C1 DIM 0.05 MIN WAS 0.13. MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY			AJS	09.11.11
A	NEW ISSUE			AJS	09.07.27
REV.	DESCRIPTION	BY	DATE		
DESIGN	AJS			DART AEROSPACE LTD	
DRAWN	JPH			HAWKESBURY, ONTARIO, CANADA	
CHECKED				DRAWING NO.	REV. C
MFG. APPR.				D3953	SHEET 1 OF 4
APPROVED				TITLE	SCALE
DE APPR.				GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29			COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS IMPRESSED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN WHOLE OR IN PART WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

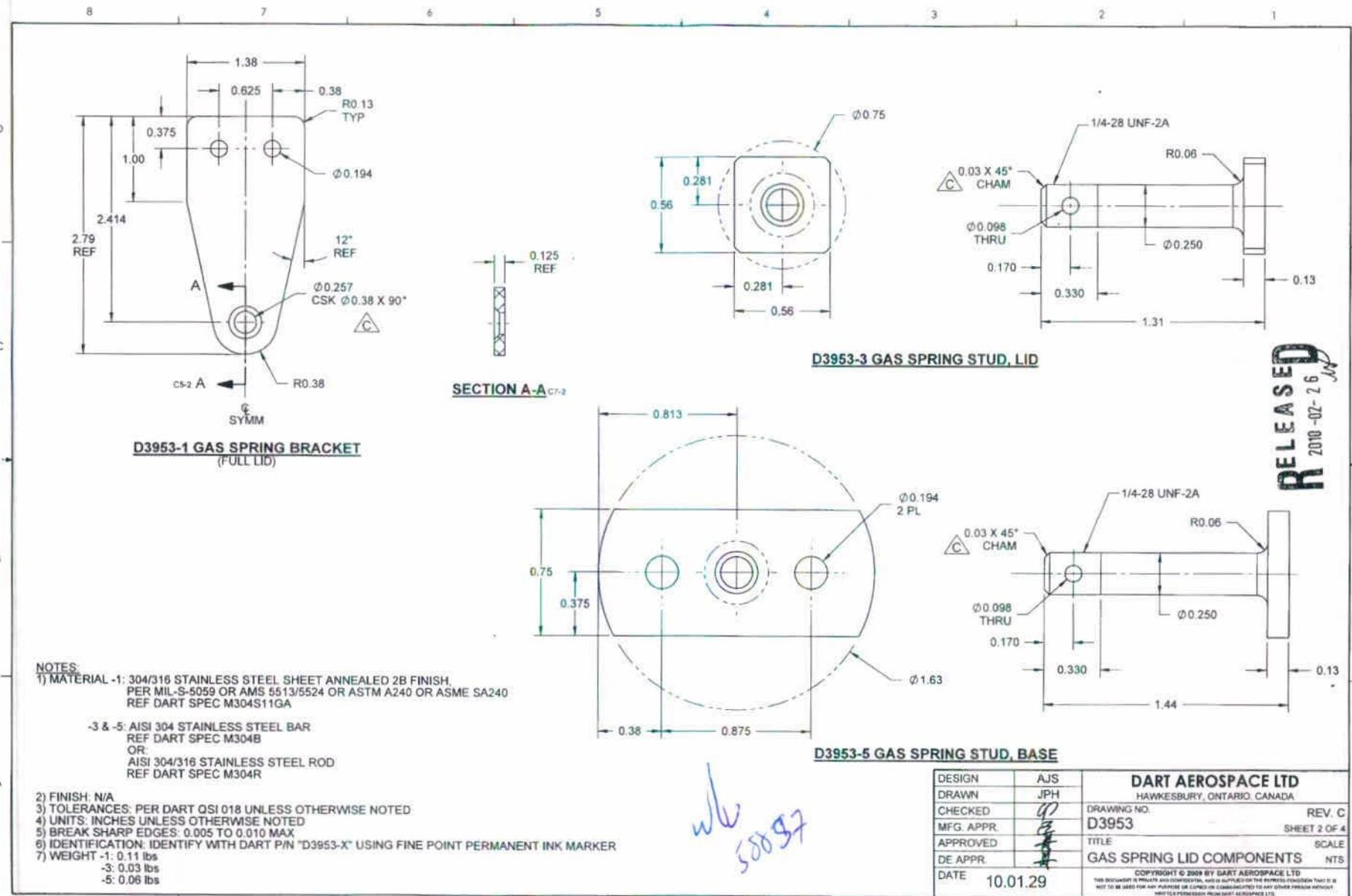
RELEASED
2010-02-26

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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PP</i>	D3953	SHEET 2 OF 4
APPROVED	<i>PP</i>	TITLE	SCALE
DE APPR.	<i>PP</i>	GAS SPRING LID COMPONENTS	NTS
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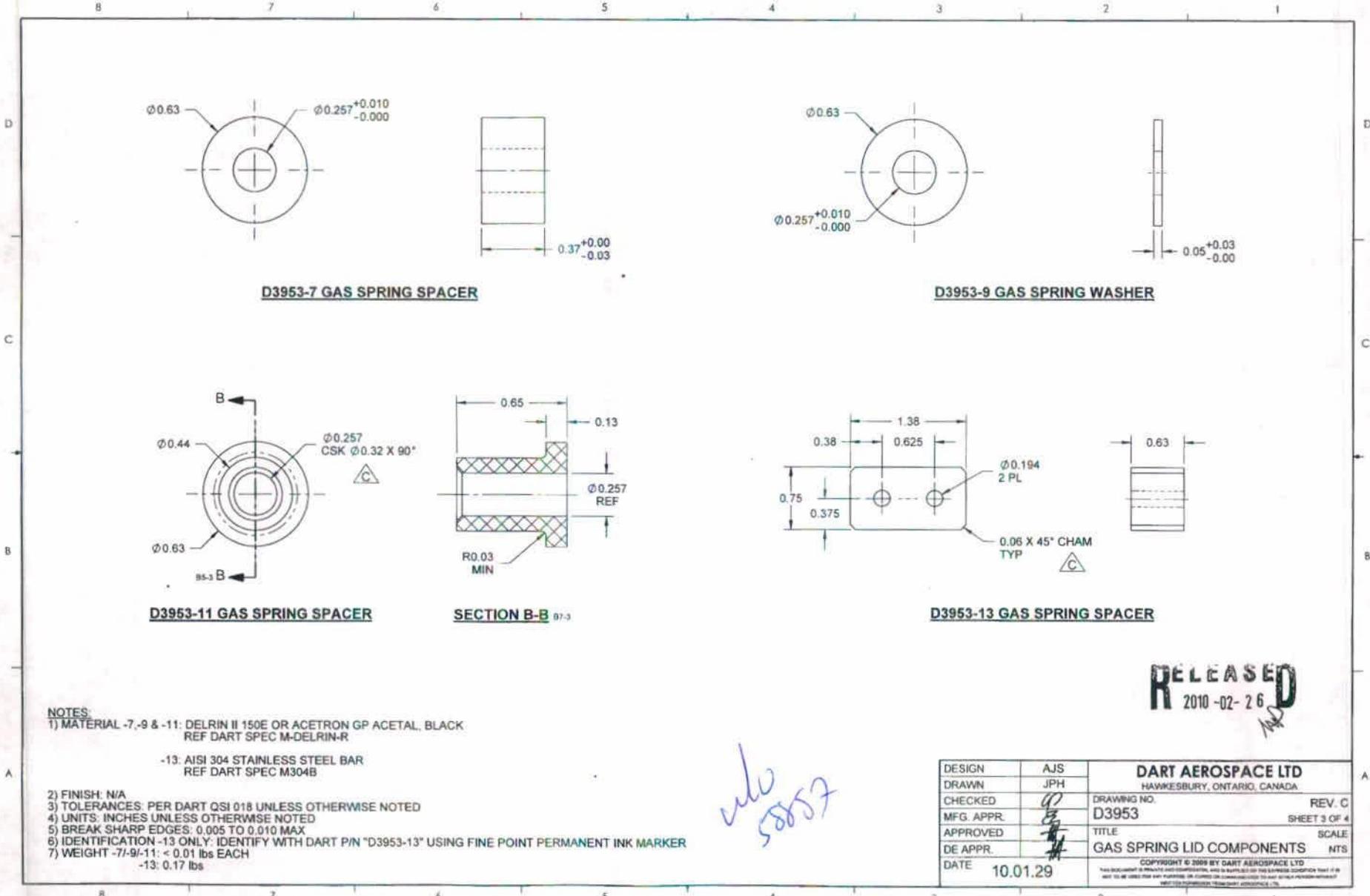
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R 2010-07-26

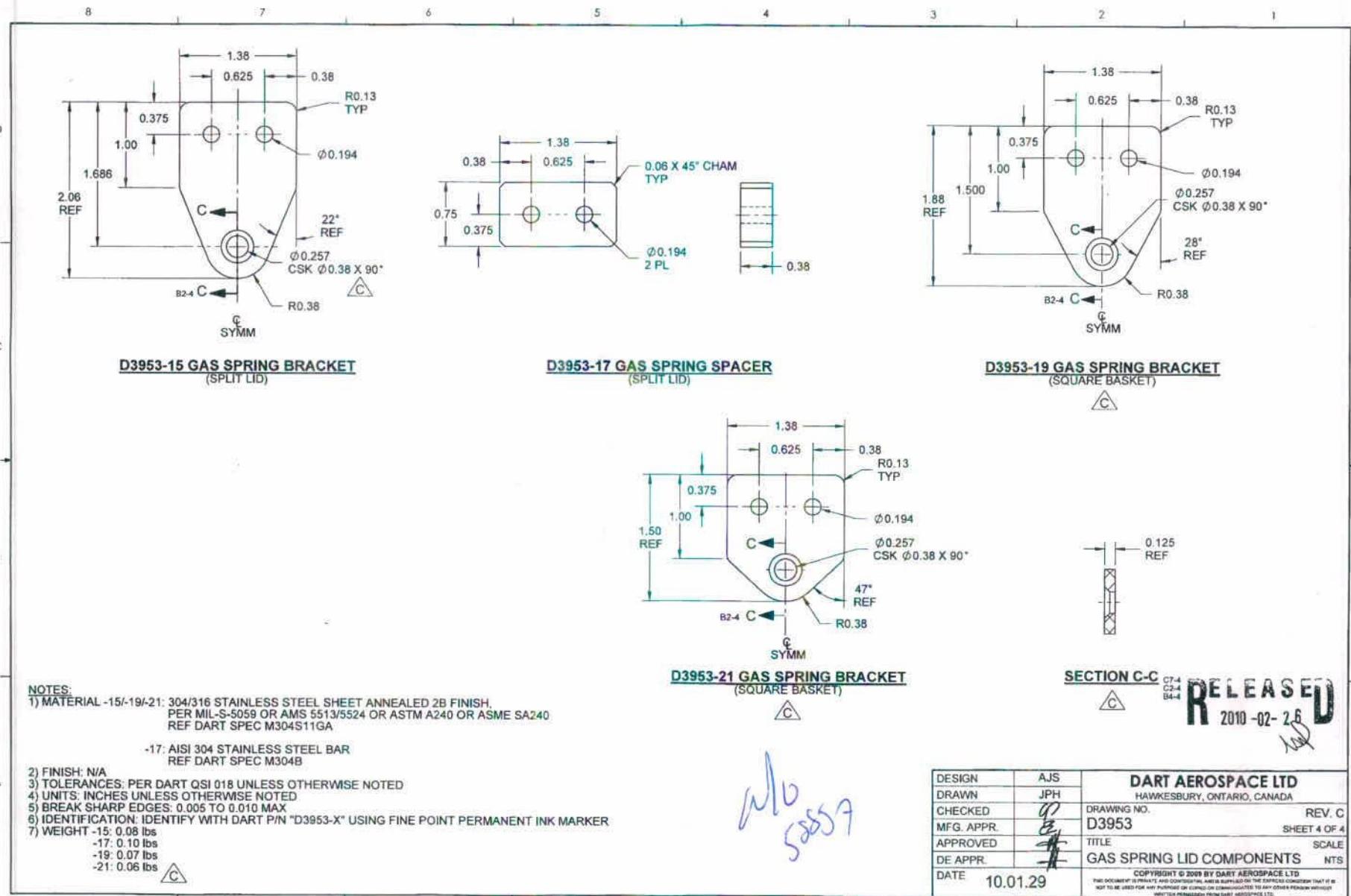
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CHECKED	<i>g</i>	DRAWING NO.
MFG. APPR.	<i>z</i>	REV. C
APPROVED	<i>z</i>	SHEET 4 OF 4
DE APPR.	<i>z</i>	TITLE
DATE	10.01.29	SCALE
		GAS SPRING LID COMPONENTS NTS

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